



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

007344

D350-567-115
Job Sheet 187002



Part No: D350-567-115

Job Qty: 2 ea

Part Name: Replacement Interior Window



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D350-567 REV.F IPP Rev:A New Issue 04-08-24 JLM IPP Rev:B CHG#2 ECN 1055 07-11-21 DD verified by:EC IPP Rev:C 08-10-07 as per revD DD verified by: IPP REV:D 13.10.15 AS PER IIN REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/21/18	12/21/18	0.00	0.00	Start Up Stores/Pkg-2		JAN 24 2019
110	Packaging	2 pcs	12/21/18	12/21/18	0.00	0.00	Packaging1-3		JAN 24 2019
120	QC	2 pcs	12/21/18	12/21/18	0.00	0.00	QC4		JAN 24 2019 69 DAS
130	Packaging	2 pcs	12/21/18	12/21/18	0.00	0.00	Packaging3-1		JAN 24 2019 69 DAS
135	DC	2 pcs	12/21/18	12/21/18	0.00	0.00	DC		JAN 25 2019 9-89
140	QC21-FG	2 Ea	12/21/18	12/21/18	0.00	0.00	QC21		JAN 25 2019 9-89

Part Op 130 - Identify and pack for shipping as per PPP D350-567-115 Location:FG032
Descriptions: 135 - Photocopy bluefile and create labels per PPP D350-567-115 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-4A	Bolt	8 Ea (4 ea)	90-Start up Operation	5112901
AN526C632R12	Screw	18 Ea (9 ea)	90-Start up Operation	5024841
D2463-0530	1/2" Seal-53"	2 pcs (1 ea)	90-Start up Operation	5131503
D3293-1	Doubler For Interior Window For -111	2 Ea (1 ea)	90-Start up Operation	5123958
D3294-1	Bracket For Interior Window For -115	2 Ea (1 ea)	90-Start up Operation	5133544
D3295-041	Replacement Interior Window For -111	2 Ea (1 ea)	90-Start up Operation	5089058
D3296-041	Replacement Interior Door For -111	2 Ea (1 ea)	90-Start up Operation	5082537
D5420-1	Doubler Plate	2 Ea (1 ea)	90-Start up Operation	5133377
DT8439	Template	2 (1 ea)	90-Start up Operation	
MS20426AD3-5	Rivet	16 Ea (8 ea)	90-Start up Operation	F4533
MS20470AD4-5	Rivet, Universal Head	4 Ea (2 ea)	90-Start up Operation	5134218
MS20470AD4-6	Rivet, Universal Head	230 Ea (115 ea)	90-Start up Operation	5048899 x 23 5131 194 x 92
MS20470AD4-7	Rivet, Universal Head	30 Ea (15 ea)	90-Start up Operation	5048900
MS21042L06	Nut	18 Ea (9 ea)	90-Start up Operation	5120515 x 13 5134222 x 5
MS21062L3	Nut Plate	8 Ea (4 ea)	90-Start up Operation	5065260
NAS1149DN632J	Washer	18 pcs (9 ea)	90-Start up Operation	5024482

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-4A	8	300	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Skid-tube ☐ Cross tube ☐ U: _____ Suspected Unap _____		AGAINST DEPARTMENT/PROCESS oval Container No: S147659 Part: D350-567-115 Job No: 187002 Serial No/Batch: S147659 Revision: F Inspector: _____ Exp Date: _____ Instructions: TC STC SH92-18 Issue Ref: FAA STC SH989NE 09/06/30, FAA STC SH989NE 09/06/30, FAA STC SH989NE 09/06/30 www.dartaerospace.com Email: sales@dartaerospace.com oval Supervisor _____ oval Coordinator _____ oval																																																																																																																																																	
Date : _____ Step #: _____ Description Work Order Deviation																																																																																																																																																					
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="4"></th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td> <td>No Re-verification</td><td>☐</td> <td>Pressure/Forced</td><td>☐</td> <td>Temperature/Cure</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Set-up</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Centre Not Concentric</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Inspection Incomplete/Unqualified</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Countersink</td><td>☐</td> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Cut Too Short</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td colspan="8" rowspan="2" style="vertical-align: top;">OTHER : _____</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </tbody> </table>						Root Cause								Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____								Misidentified	☐	Past Due	☐
Root Cause																																																																																																																																																					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																																										
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐																																																																																																																																										
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐																																																																																																																																										
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐																																																																																																																																										
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																										
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐																																																																																																																																										
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐																																																																																																																																										
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐																																																																																																																																										
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐																																																																																																																																										
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																										
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____																																																																																																																																																	
Misidentified	☐	Past Due	☐																																																																																																																																																		

AN526C632R12	18	246	0
D2463-0530	2	4	0
D3293-1	2	11	0
D3294-1	2	3	0
D3295-041	2	5	0
D3296-041	2	6	0
D5420-1	2	2	0
DT8439	2	0	0
MS20426AD3-5	16	1,940	0
MS20470AD4-5	4	801	0
MS20470AD4-6	230	734	0
MS20470AD4-7	30	1,550	0
MS21042L06	18	157	0
MS21062L3	8	61	0
NAS1149DN632J	18	116	0

Part Specifications

Specifications could not be found.

Plex 11/23/18 1:37 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							